Each

Thursday, 8/30/2007 3:49:28 PM Date User: Kim Johnston **Process Sheet Drawing Name** : BUSHING : CU-DAR001 Dart Helicopters Services Customer Job Number : 34348 **Estimate Number** : 10725 : D2652 Part Number P.O. Number : 8/30/2007 S.O. No. : 山人 **Drawing Number** · D2652 REV A This Issue : N/A Prsht Rev. Project Number : MACHINED PARTS First Issue **Drawing Revision** : 34074 :NA Material **Previous Run Due Date** : 9/21/2007 Qty: 200 Um: Written By Checked & Approved By NG Comment : Est Rev:B 02.06.13 Now machined in house. Additional Product Job Number: Machine Or Operation: Description: Seq. #: 1.0 M303R0500 303 Round Bar 0.500" Comment: Qty.: 11.5500 f(s) 0.0578 f(s)/Unit Total: Material:303 ss .500" Round Bar (M303R0500) Batch: M105839 2.0 Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA250 & Dwg D2652 DIP 07/10/10 2-Deburr 3.0 QC2 PARTS AS THEY COME OFF MACHINE 4.0

Comment: SECOND CHECK

PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:_

C 1/10/12

5.0

Dart Aerospac	e Lt	d
---------------	------	---

	WORK ORDER CHANGES						W/O:		
Approval QC Inspector	Approval Chief Eng / Prod Mgr	Qty	Date	Ву	OCEDURE CHANGE	PRO		STEP	DATE
_	Date:			NCR: Yes	Fault Category:	PAR #:			Part No

Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: <u>071/01/0</u>
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC Corrective Action Section B			Verification	A1	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
		- And the state of						
						·		
					1	1	İ	

NOTE: Date & initial all entries

Date:

Thursday, 8/30/2007 3:49:28 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 34348

Part Number: D2652

Job Number:



Seq. #:

Job Completion

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

M Alorp

Dart Ae	rospace	Ltd						
W/O:			V	VORK ORDER CHANG	ES			,,,,
DATE STEP		PROCEDURE CHANGE			PROCEDURE CHANGE By		Approval Chief Eng / Prod Mgr	Approval QC Inspector
<u> </u>								
Part No):	PAR #: _	Fault Ca	tegory:	_ NCR: Yes	No DQA:	Date: _	
					QA: N	/C Closed:	_ Date: _	
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NCR)		
		Description of NC		Corrective Action Section	on B	Verification	Approval	Approval
DATE STEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

Sign & Date	Verification Section C	Approval Chief Eng	Approva QC Inspecto
		Chief Eng	QC inspecto
			<u> </u>
			:
			-
-	·		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34348
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST							
٠		First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
0.600	+/-0.010	0.602					
0.060	+/-0.005	0.060					
Ø0.305	-0.002/+0.000	0.3045	/				
Ø0.191	+0.005/-0.000	0,1935					
Ø0.500	+/-0.010	0.4985					
0.030 x 20°	+/-0.010	.03 × 20°	/				
R0.010	+0.010/-0.000	0.015	/				
		A 114 1 B		<i>/</i>			

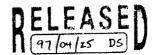
Measured by: D	Audited by:	Prototype Approval:	N/A
Date: 07/10/10	Date: 07/	Date:	

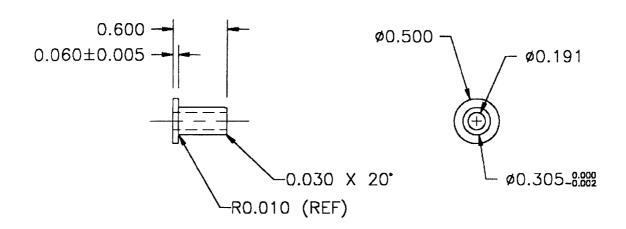
Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	. 4





DESIGN	DRAWN BY	DART AEROSPACE FAIRCHILD INTERNATIONAL	
CHECKED	APPROVED (I) (I)	D2652	REV. A
DATE		TITLE	SCALE
97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX SHOP COPY TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE REMORTED

ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO 34348